

CLAIMS

- [1] An extrusion molding machine for a resin tube, comprising extruders (6, 7) for thermally melting resins (3, 4) to enable their extrusion, and a die (11) having tube molding passages (9, 10) for forwardly passing therethrough resins (3, 4) extruded from the extruders (6, 7) to enable the molding of the tube (2), said extrusion molding apparatus for a resin tube being characterized in that flow adjusting valves (34, 35) are installed which enable the adjustment of the respective flows per unit time of the resins (3, 4) passing from said extruders (6, 7) to the tube molding passages (9, 10).
- [2] In an extrusion molding apparatus for a resin tube, with said die (11) formed with inflow passages (21, 22) enabling the resins (3, 4) extruded from said extruders (6, 7) to flow into the rears of said tube molding passages (9, 10),
an extrusion molding apparatus for a resin tube as set forth in Claim 1, characterized in that the degrees of opening of said inflow passages (21, 22) are made adjustable by said flow adjusting valves (34, 35).
- [3] An extrusion molding apparatus for a resin tube as set forth in Claim 1 or 2, characterized in that communication passages (43) for communicating the intermediate portions of said inflow passages (21, 22) to outside said die (11) are made openable/closable by said flow adjusting valves (34, 35).
- [4] An extrusion molding apparatus for a resin tube as set forth in Claim 3, characterized in that opening-degree adjusting valves (44) are installed for making the degrees of opening of said communication passages (43) adjustable.
- [5] An extrusion molding apparatus for a resin tube, comprising a plurality of extruders (6, 7) for thermally melting and extruding resins (3, 4) of different kinds, and a die (11) provided with an inner layer tube molding

passage (9) for forwardly passing therethrough the resin (3) extruded from one extruder (6) of these extruders (6, 7) to enable the molding of an inner layer tube (2a), and an outer layer tube molding passage (10) for forwardly passing therethrough the resin (4) extruded from the other extruder (7) to enable the molding of an outer layer tube (2b) which is to be externally fitted integrally on said inner layer tube (2a), said die (11) enabling the molding of a multi-layer tube (2) by these inner and outer layer tubes (2a, 2b), said extrusion molding apparatus for a resin tube being characterized in that

flow adjusting valves (34, 35) are installed which enable the adjustment of the respective flows per unit time of the resins (3, 4) extruded from said extruders (6, 7) and passed said inner and outer layer tube molding passages (9, 10).

[6] An extrusion molding apparatus for a resin tube as set forth in Claim 5, characterized in that the inner and outer extrusion ports (17, 18) constituting the respective front ends of said inner and outer layer tube molding passages (9, 10) are disposed radially close to each other and are opened forwardly of the front end surface (19) of the die (11) and separately from each other.

[7] In an extrusion molding apparatus for a resin tube, with said die (11) formed with a through-hole (24) longitudinally extending through said die (11) and extending inwardly of said inner layer tube molding passage (9), said tube (2) being externally fitted on the core material (25) forwardly passing through said through-hole (24),

an extrusion molding apparatus for a resin tube as set forth in Claim 6, characterized in that said inner extrusion port (17) of said inner layer tube molding passage (9) is disposed close to the front end opening (26) radially constituting the front end of said through-hole (24).